

Date: Monday, 10/22/2007 10:34:37 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP WELDMENT	
Job Number	: 35263 <i>13</i>		Part Number	: D3562042	
Estimate Number	: 12577		Drawing Number	: D3562 UNDER REVIEW	
P.O. Number	:		Project Number	: N/A	
This Issue	: 10/22/2007	S.O. No. :	Drawing Revision	: C	
Prsh Rev.	: NC		Material	:	
First Issue	: / /	Type :	Due Date	: 11/10/2007	
Previous Run	: 34270		Qty:	/ 5 Um: Each	
Written By	:		Comments		
Checked & Approved By	:		Comments		
Comment	Est Rev: A	New Issue	06-11-09	JLM	
	Est rev B	ECN 987	07.10.09	EC	verified by: DD

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>534694 = 1</i> <i>B34696 = 4</i>

Check Material for any Dents or Defects

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAW

07-11-06

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 35263

Part Number: D3562042

Job Number:



Seq. #: Machine Or Operation:

Description:

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07.11.19 61

6.0 D3560042

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
ARM WELDMENT

1335030 am 07.11.19 5

7.0 D3560044

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
ARM WELDMENT

1335032 am 07.11.19 5

8.0 MS20600AD4W

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total: 180.0000 Each(s)
Blind Rivet

am 07.11.19 5

batch: 10105973

batch: 10105973

Comment: SMALL & MEDIUM FAB RESOURCE 1

SMALL & MEDIUM FAB RESOURCE 1



PT

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond*****

07.11.19 5

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10105973

11.0 D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

2 D2734

Description Batch

End Cap 1334485

107.11.19 4

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 35263

Part Number: D3562042

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024,

A/R: Aluminum Rod M165058

11-07-11-22 4

2-Grind end cap welds flush as per Dwg D3562

11-07-11-23

11-07-11-23

13.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

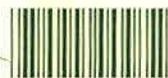
11-07-11-23

11-07-11-23

11-07-11-23

14.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11-07-11-23 4

15.0 POWDER COATING

POWDER COATING



11-07-11-23 4

11-07-11-23

M165914

11-07-11-23 4

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11-07-11-23

11-07-11-23

16.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

11-07-11-23

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M16603

11-07-11-23

11-07-11-23

17.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11-07-11-23

18.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

11-07-11-23

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 35263

Part Number: D3562042

Job Number:



Seq. #: Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

P08111/07

Job Completion:

*U 8/16/28*

DART

RELEASED
07.06.21

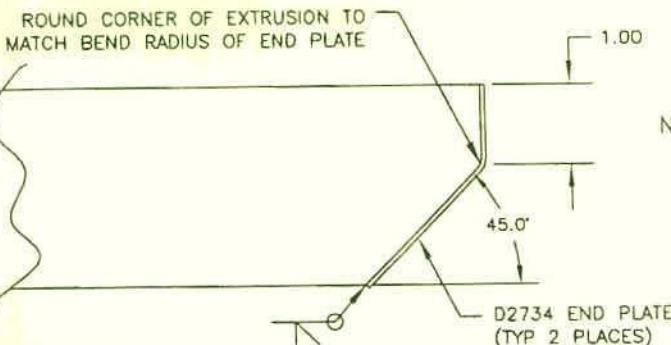
UNDER REVIEW

07.10.22 DC

OK PER REV C

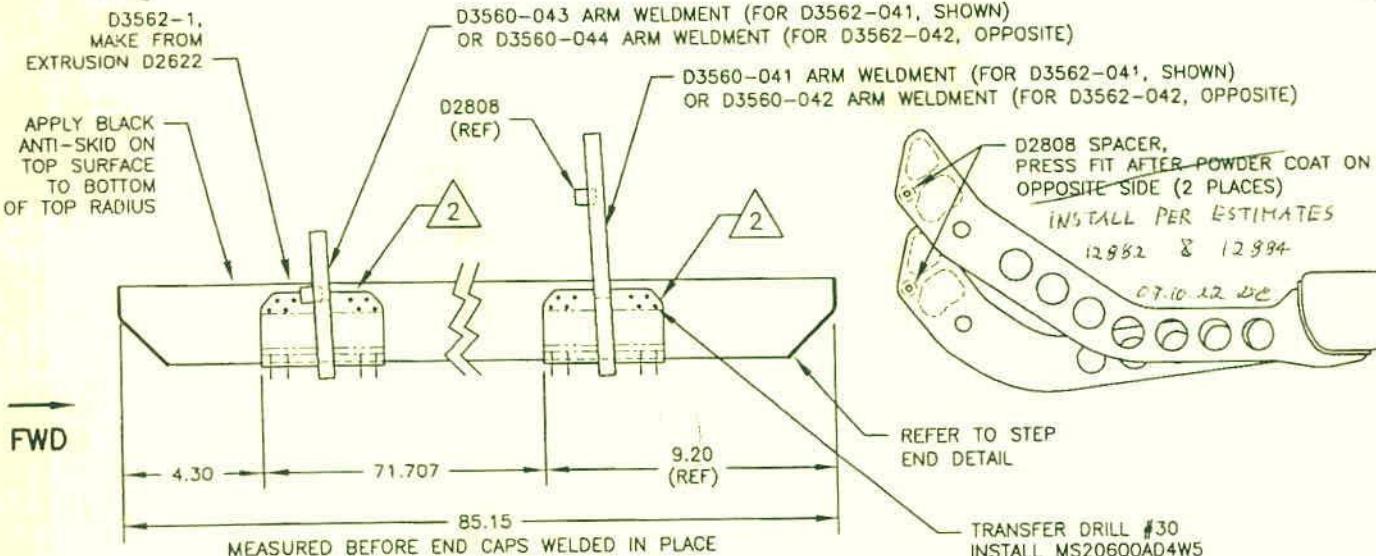
07.10.22 DC

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35263



D3562-041 LH STEP ASSEMBLY (SHOWN)

D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
DATE	APPROVED	DRAWING NO.
07.06.19		D3562
		STEP ASSEMBLY
		TITLE
A	06.09.26	NEW ISSUE
B	07.01.15	ARMS NOW RIVETED TO STEP
C	07.06.19	NOW MAGBND, ADD D2808, RMV 4 RVTS
		SCALE
		NTS
		REV. C
		SHEET 1 OF 1

